

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026124**Date Inspected:** 18-Aug-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Fred Vonhoff		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	OBG Components	

**Bridge No:** 34-0006**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

**In Process Visual Inspection****East Line**

This QA randomly observed ABF/JV qualified welder Mike Jiminez #4671 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1110A-R1. The joint being welded was a 14mm plate insert at the "A" deck to close the lifting lug deck penetration holes. This work was located at E4-PP79-L#1, 3 and was performed in the overhead position from the bottom side of the "A" deck.

During welding, ABF Quality Control (QC) Fred Vonhoff was noted monitoring the welding parameters. Welding parameters were recorded as (A=127).

**Approximately-**

8:20- this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the completed welds at this panel point E4-PP79-L#1, 3 location. Mr. Vonhoff recorded no rejectable indications at this time.

11:10- this QA observed QC Fred Vonhoff perform Magnetic Particle (MT) of the back gouged welds at this panel point E4-PP77-L#2, 4 location. Mr. Vonhoff recorded no rejectable indications at this time.

11E/12E

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

This QA randomly observed ABF/JV qualified welder Jimmy Zhen #6001 performing Flux Core Arc Welding w/gas (FCAW-G) and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3042B-1. The joints being welded were in the 3G vertical position at the side plate E1 on the outside of the OBG 11E/12E.

During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters. Welding parameters were recorded as (A=165/V=24.6).

Approximately-

9:30 this QA observed QC personnel performing shear wave Ultrasonic Testing (UT) of the Complete Joint Penetration (CJP) designated 11E/12E side plate "C" from the internal side.

12:00 this QA observed ABF welding personnel performing grinding excavation of weld locations previously UT tested and rejected by QC technicians.

In process excavation locations observed are:

11E/12E-C1 (Y=5150, L=30)

11E/12E-C1 (Y=4890, L=140)

11E/12E-C1 (Y=4660, L=30)

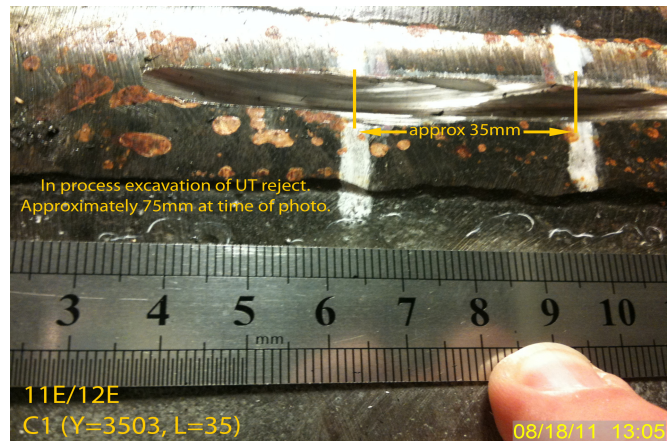
11E/12E-C1 (Y=4470, L=150)

11E/12E-C1 (Y=4250, L=40)

11E/12E-C1 (Y=3503, L=35)

Measurements noted above are in process observations. Location, Length, Width, and Depth measurements will be recorded as final upon completion of the excavation process.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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<b>Inspected By:</b>	Clifford, William	Quality Assurance Inspector
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<b>Reviewed By:</b>	Levell, Bill	QA Reviewer
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